

# Work Order ID 51998

September 11, 2009 1:05:03 PM



Page 1

Item ID: D3324-041

Accept



Setup Start



Revision ID: B

Item Name: Basket Base Assembly

Stop



Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MP

Date: 09/09/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

3	D3324-1	Bottom Tube	M109385
---	---------	-------------	---------

4	D3324-3	Full Length Tube	M109385
---	---------	------------------	---------

2	D3324-5	Top End Tube	M109385
---	---------	--------------	---------

2	D3324-7	Bottom End Tube	M109385
---	---------	-----------------	---------

10	D3324-9	Vertical Tube	M109385
----	---------	---------------	---------

SAD 09-09-15

dy 09/09/10 (lx)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.09.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 51998**

September 11, 2009 1:05:03 PM

Page 2

Item ID: D3324-041

Accept

Revision ID: B

Item Name: Basket Base Assembly

Start Date: 09/11/2009 Start Qty: 1.00

Required Date: 09/21/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

275 02/10/01



QC

Memo

0.00

(4)

4

Quality Control

121

Pressure Wash per QSI005 4.3

0.00

Bk 09-10-01



HandFinish

Memo

0.00

①

Hand Finishing

POSITIVE RECALL  
EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 51998

September 11, 2009 1:05:03 PM



Page 3

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Stop



Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112260

Memo

1ST COAT:

START TIME: 10:15am

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:45pm

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT: 11:00am

START TIME: 11:00am

OVEN TEMPERATURE: 400°F

11:30am

0.00

⇒ Hl 09/10/09

(X1)

Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9/30/09/10/05②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 51998

September 11, 2009 1:05:03 PM



Page 4

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Revision ID: B

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Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

51994

U

Packaging

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

09/10/07   
1MF 09-10-05

POSITIVE RECALL

EFFECTIVE 09-10-01

RELEASED 

AUTH 

DATE 09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

September 11, 2009 1:05:03 PM

Page 1

Work Order ID: 51998

Parent Item: D3324-041RevB

Parent Item Name: Basket Base Assembly


Start Date: 09/11/2009

Required Date: 09/21/2009


Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3328-3RevB		Manufactured	No			100	Each	40.0000	2.0000			
												
Basket Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
33872	40	

D3348-1RevB		Manufactured	No			100	Each	29.0000	4.0000			
												
Clevis												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
41830	5	
44246	24	

D3349-3RevA		Manufactured	No			100	Each	12.0000	2.0000			
												
Spacer Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	12	
41831	12	

2x *SY* 09/09/30

1x  
3x *SY* 09/09/30

2x *SY* 09/09/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 11, 2009 1:05:03 PM

Page 2

Work Order ID: 51998

Parent Item: D3324-041RevB

Parent Item Name: Basket Base Assembly


Start Date: 09/11/2009

Required Date: 09/21/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3367-1RevA  Mounting Bracket		Manufactured	No			100	Each	47.0000	2.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    47

43228    47

M4130NTS0.500W.035                      Purchased                      No



4130 Square tube .500 x .500 x .035w

100                      f                      330.1931                      49.0526



2x *SY 09/09/30*

SAD 09-09-15

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT    330.1931

109127    196.8684

109385    133.3247

M569EX0.50-18F                      Purchased                      No



569 Expanded Metal

100                      sf                      186.0000                      28.0000



End Bar Scrap B# 109385 Qty 2.35

49.0526

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT    186

101927    18

107677    32

109289    136

*M 112 776*

28.00 *SY 09/09/30*

September 11, 2009 1:05:03 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
DRAWING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

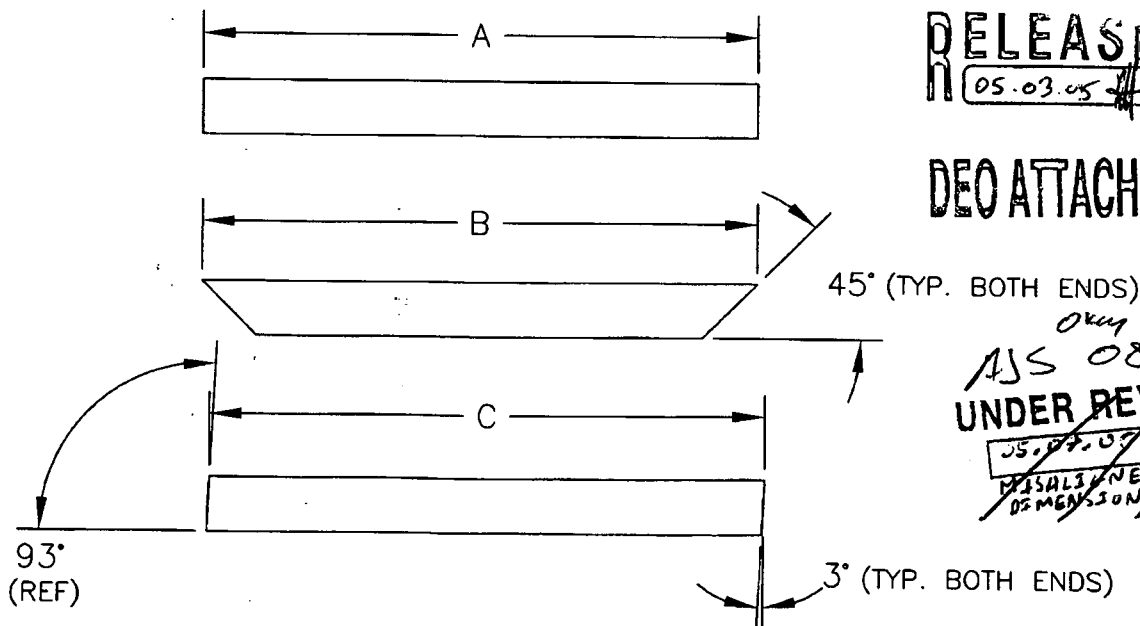
WORK ORDER

NO. 51998  
MF 09-09-11

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>#</b>	APPROVED <b>#</b>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED  
05.03.05

DEO ATTACHED

OKAY  
AS 08.12.15  
UNDER REVIEW  
05.04.07 PH  
DISALIGNED  
DIMENSION PUA

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL  
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

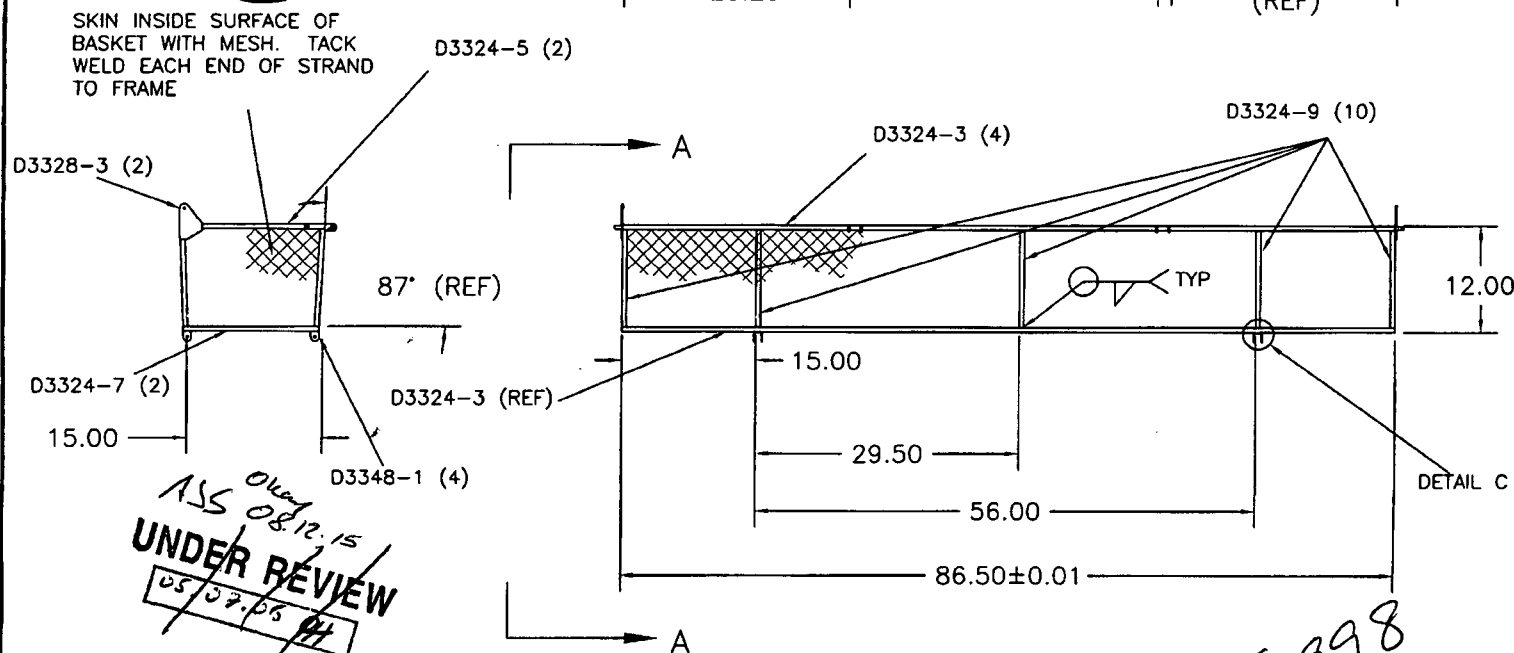
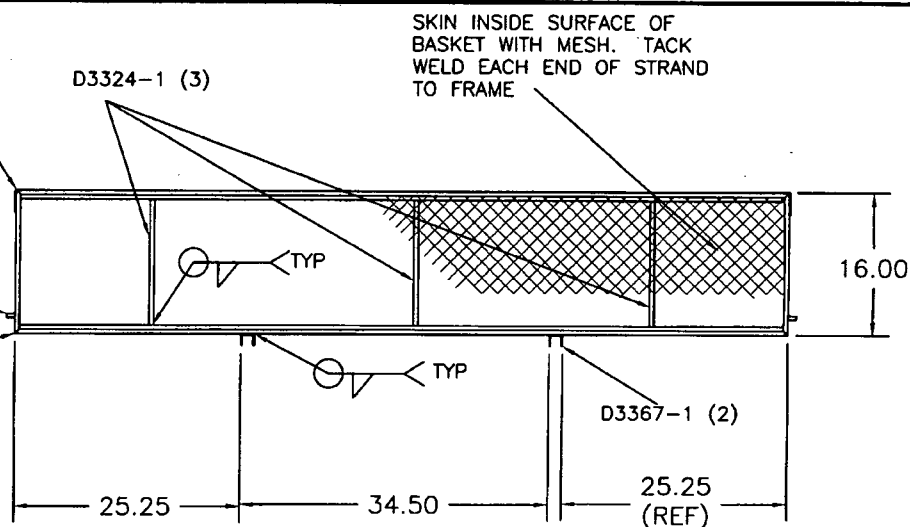
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAMKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
		TITLE	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE	1:20	



#### D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED  
05-03-05

DEATTACHED

155 08.12.15  
UNDER REVIEW  
05/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

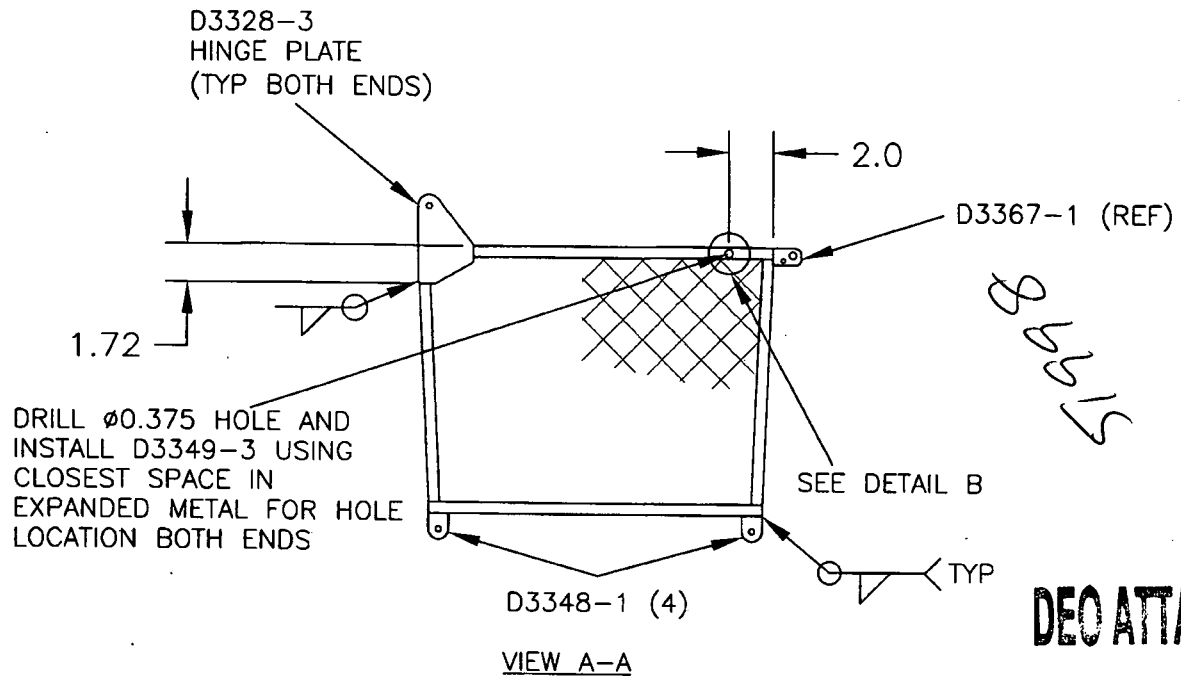
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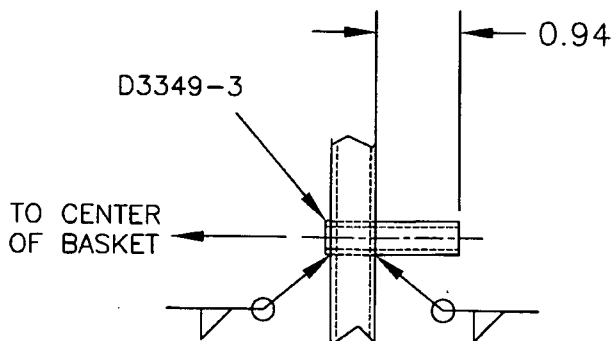


**DART**

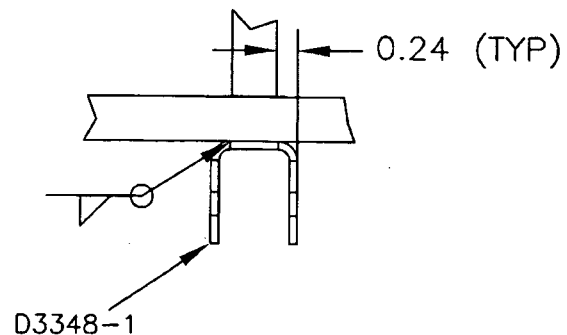
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



RELEASED  
05.03.05



DETAIL B  
(SCALE 1:2)



DETAIL C  
(SCALE 1:2)

*Okay*  
*ASS 05.12.15*  
**UNDER REVIEW**  
05.07.06

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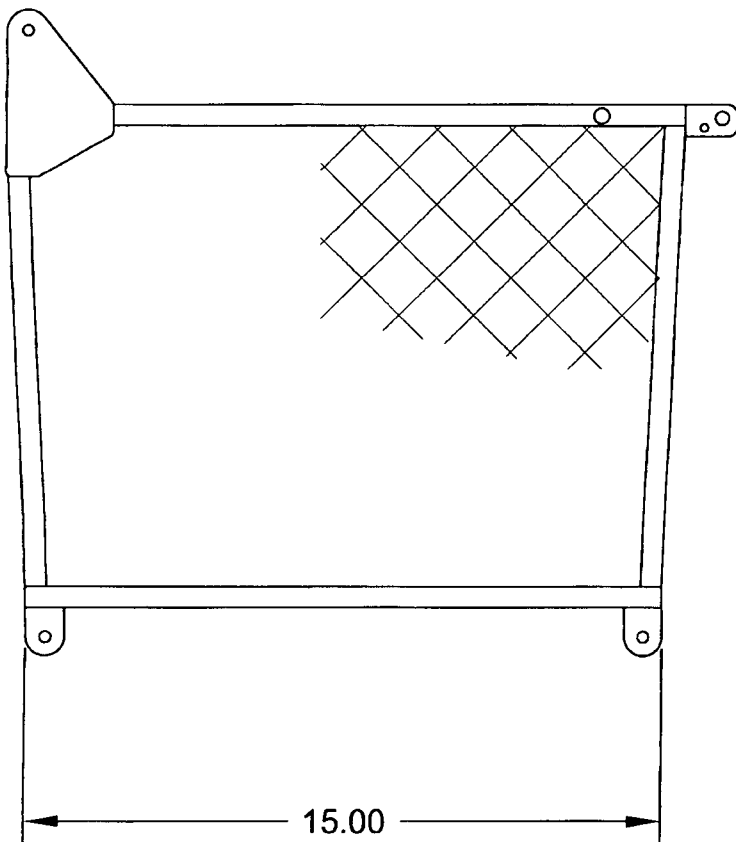
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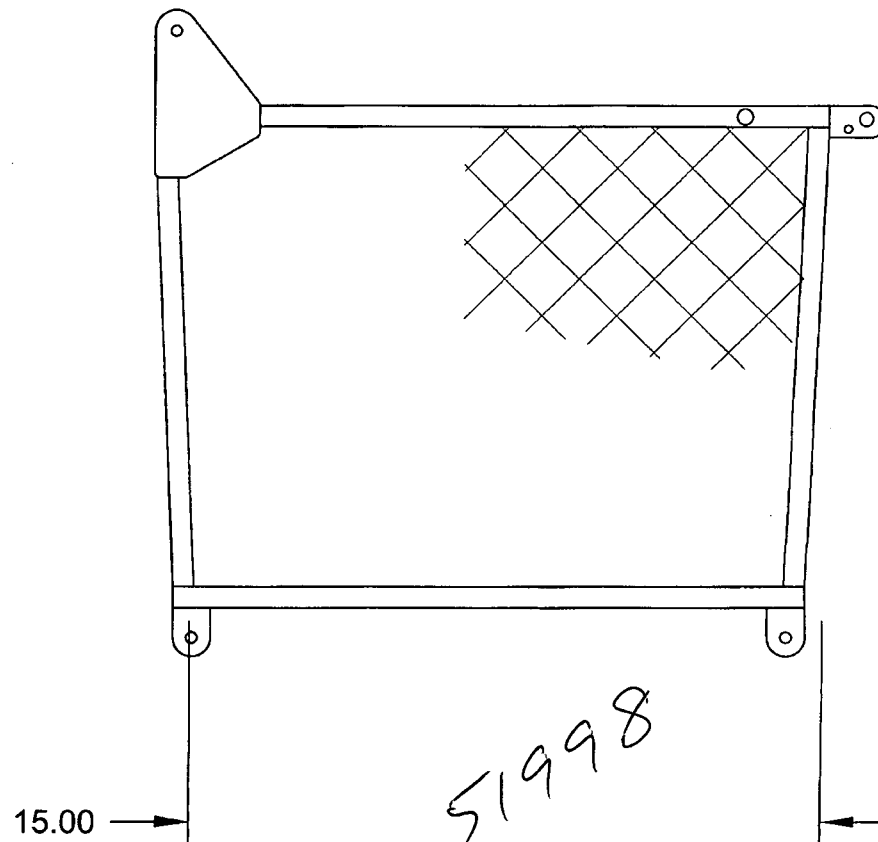
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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